

Work Order ID 79367

79367

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Wednesday, January 25, 2012 12:31:07 PM

Item ID: D3208-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Mount Angle
 Start Date: 1/25/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3208	Rev A1	

100	FLOW WATER JET	0.00	
100			
Waterjet	Memo	0.00	
FLOW CNC Waterjet	1-Cut as per Dwg D3208 Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u> 2-		
<u>6061.003</u>	Deburr if necessary		
110	QC2- Inspect parts off machine FAI/FAIB	0.00	
110			
QC	Memo	0.00	
Quality Control			
120	QC8- Inspect parts - second check	0.00	
120			
QC	Memo	0.00	
Quality Control			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00				(3)			
Brake NC	Memo Deburr D3208-3 Form D3208-3 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208	0.00							SB 12/02/09
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				(X8)			
Quality Control	Memo	0.00							8 12/02/09
150 *150* Hand Finish	Chemical Conversion Coat per QSI005 4.1	0.00				8			BK 12-2-8
Hand Finishing	Memo	0.00							

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Wednesday, January 25, 2012 12:31:08 PM

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Item Name: Pedal Mount Angle
Start Date: 1/25/2012 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 2/3/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>5202</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

8. SP12-02-09.
↓
8X PM-12/02/09

12/2/13

1202-10
(4)

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 79367

79367

Parent Item: D3208-3

D3208-3

Parent Item Name: Pedal Mount Angle

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B04.05.25Material changed for Step 4KJ/JLM
IPP Rev:C Now on Waterjet 06-10-12 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

352.5696

0.0659

0.554947

M6061T6S 063

WJ 12.02.07

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

352.5695684

113608

0

116308

11.4555684

117285

75.414

119331

49.2

119802

25.5

120218

191

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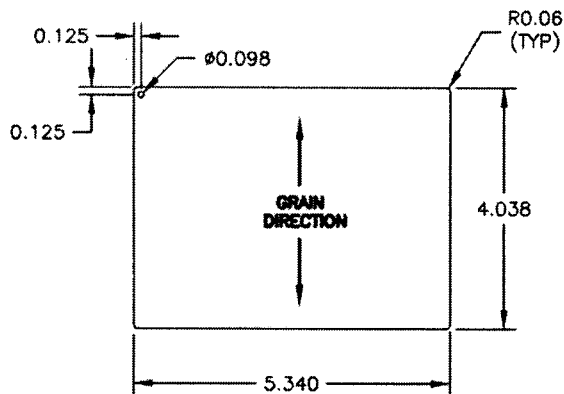
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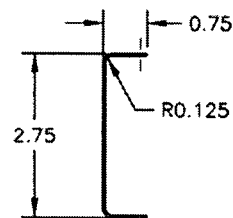


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A	04.01.27	NEW ISSUE	
AI	04.05.25	CHANGE DIM; NOTE 3) CHANGE	

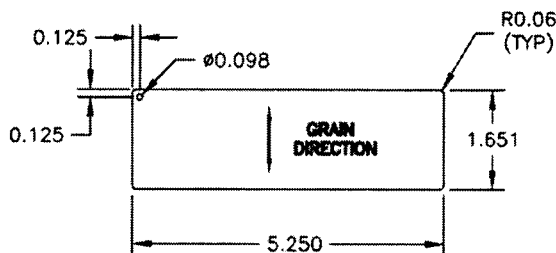
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04 04 05



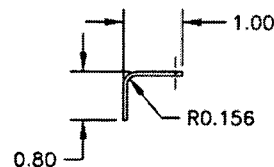
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

SHOP COPY

REVISION TO

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NO REVISIONS

WORK ORDER

NO. 79367

M.C.S.

12/01/25

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



3) MATERIAL: 6061-T6 (QQ-A-250/4) 0.063" THICK (M6061T6S.063)

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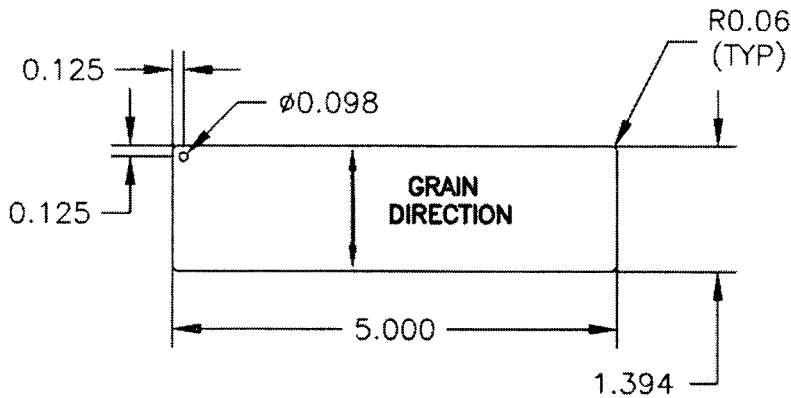
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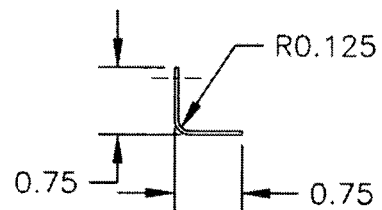


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DATE 04.01.27	TITLE DOUBLER		SCALE 1:2

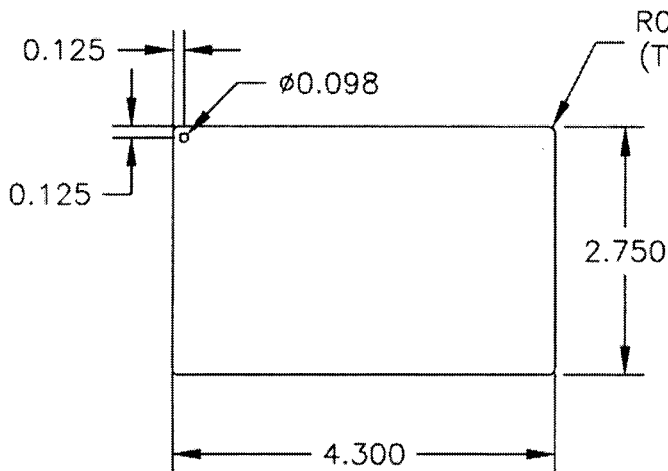
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04.04.05 HT



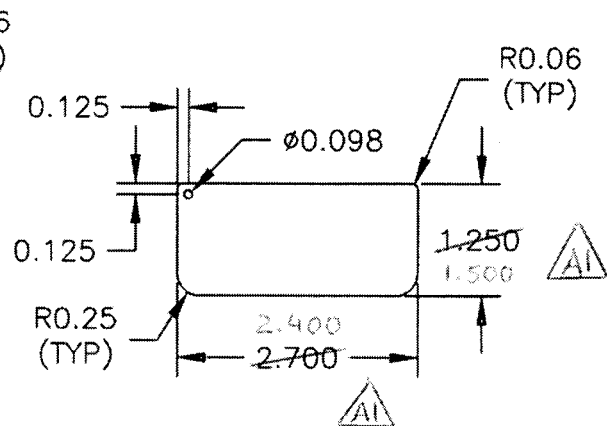
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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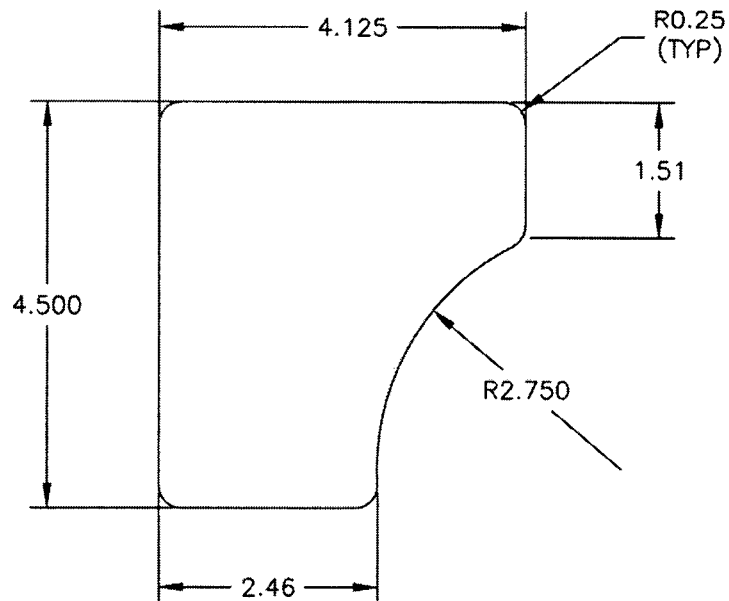
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04.04.05 [Signature]



D3208-9 DOUBLER

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